

Date: Thursday, 3/2/2006 3:07:52 PM
 User: Kim Johnston

Process Sheet

25677
679
26019
26060
61

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE BRACKET
 Job Number : 26035
 Estimate Number : 10348
 P.O. Number : N/A Part Number : D28581
 This Issue : 3/2/2006 S.O. No. : N/A Drawing Number : D2858 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 24503 Material : N/A
 Due Date : 3/22/2006 Qty: 24 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : J.L. 06.03.02
 Comment : Est C 00.06.22 Removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X01250 6061-T6 Bar 1.5" x 1.25"



Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s)

Material: 1.50" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B15001250)

Batch M18600 - 6 parts

M100384 - 2 parts

J.L. 06.04.01 8

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 6.02"

Note: 1 Blank Makes 3 Parts

J.L. 06.04.01 8

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2858- |

J.L. 06.04.02 24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. 06.04.02 24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PS Date: 06/04/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:52 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 26035

Part Number: D28581

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

J-L 06.04.02 (24)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

SAD 06.04.02 (24)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06.04.03

24

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

06.04.10 (24)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

FC 06 04 13 (24)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST391

AP 06/04/13 (24)

11.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/17

Job Completion



06/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

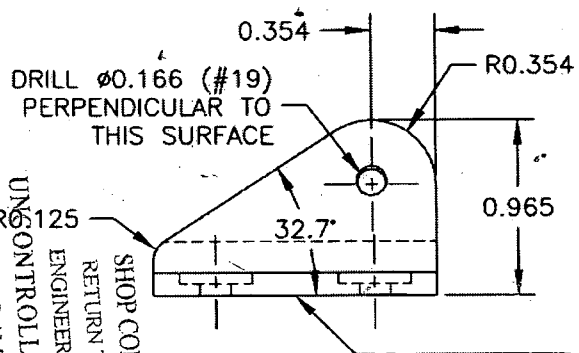
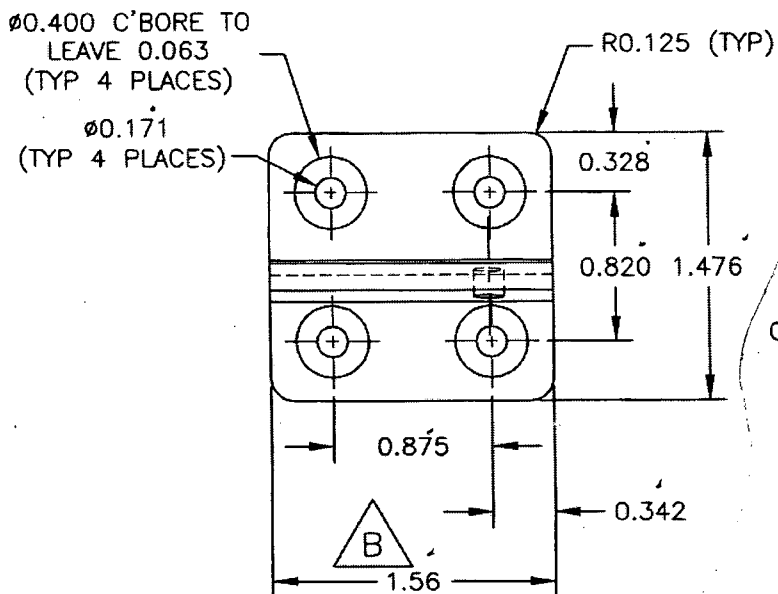
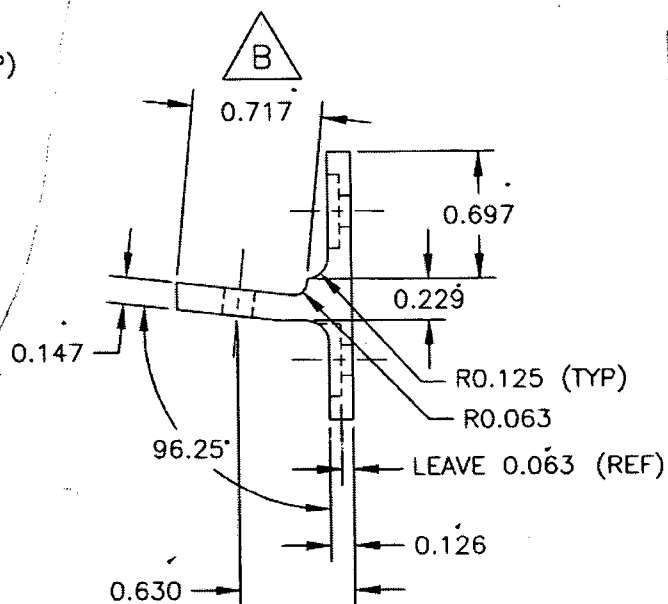
NOTE: Date & initial all entries

DART



RELEASED
99.07.03 KE

DESIGN	VE	DRAWN BY	KE	DART AEROSPACE LTD
CHECKED	UC	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	99.02.28	DRAWING NO.	D2858	REV. B
		TITLE	HINGE BRACKET	SHEET 1 OF 1
				SCALE 1:1
	A		98.12.14	NEW ISSUE
	B		99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 26035
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

Work Order: 26035

Description: hinge bracket

Part Number: D 2858-1

Inspection Dwg: D2858 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.400X.063	+ - .010	.400X.062	✓			
Ø.171	+ - .005	.173	✓			
.875	+ - .010	.875	✓			
1.56	+ - .030	1.562	✓			
.342	+ - .010	.342	✓			
1.476	"	1.476	✓			
.820	"	.820	✓			
.328	"	.328	✓			
Ø.166	+ - .005	.168	✓			
.354	+ - .010	.354	✓			
.965	"	.967	✓			
1.47	"	1.473	✓			
.630	"	.631	✓			
1.26	"	1.28	✓			
.063	"	.069	✓			
.229	"	.229	✓			
.697	"	.695	✓			
.717	"	.723	✓			
5-125	"	5-125	✓			
1.063	"	1.063	✓			

Measured by:	J.L
Date:	06.04.01

Audited by:	<i>ES</i>
Date:	06/04/07

Prototype Approval: _____
Date: _____

Rev	Date	Change
A		New Issue

Revised by: Approved:
KJ/RF